

Work Order ID 62572

Monday, October 04, 2010 2:26:32 PM



Page 1

Item ID: D412-630-032 ✓

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 10/4/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D412-630	Rev M

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG003

[Handwritten signature]

10-10-20
(1)

110 0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

A/R MS20995C41 batch: *4101537*

9/30/10/18 *(1)*

120 0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

****ensure tension to retract step is 11 to 18 lbs ****
Test fit on aircraft in Eng. lab.

[Handwritten signature]
1

10/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Pick Kit		0.00							
Packaging	Memo	0.00							10/10/18.5
Packaging									See PTO
140 QC	QC4- 100% Inspect kits for completeness	0.00							
Quality Control	Memo	0.00							10/10/19
150 Packaging	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-032								
	Location: _____								
	PPP Rev: _____								

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Revision ID:

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Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/2010

mf
10-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 62572

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)



Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
 IPP REV. B 05.12.19 updated pick list EC
 IPP REV. C 07.11.12 ecn 1019, nochg EC verified by: DD IPP Rev: D
 10.05.28 added route seq DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN310-4 NUT		Purchased	No			130	Each	31.0000	2	1			
----------------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

ST324 31
 115107 31

AN310-5 NUT		Purchased	No			130	Each	49.0000	2	2			
----------------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

ST324 49
 114830 49

AN3C5A Bolt		Purchased	No			130	Each	1,342.000	3	3			
----------------	--	-----------	----	--	--	-----	------	-----------	---	---	--	--	--

Location Loc Qty Loc Code

ST350 1332
 114330 11
 115015 16
 115316 105
 115422 100
 115594 100
 115835 500
 115835 500
 ST351 10
 113121 10

10/10/10

10/10/10

10/10/10

10/10/10

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 62572

Parent Item: D412-630-032
















Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

 AN44-C12  eyebolt	Purchased	No		130	Each	12.0000	1		10/10/10sf
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST362	12					
			114669	12					
 AN4C15  BOLT	Purchased	No		130	Each	25.0000	1		10/10/10sf
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST358	25					
			113908	5					
			114669	20					
 AN5C11  BOLT	Purchased	No		130	Each	42.0000	1		10/10/10sf
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST337	42					
			113950	12					
			114801	30					
 AN5C15  BOLT	Purchased	No		130	Each	18.0000	1		10/10/10sf
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST338	18					
			114669	18					
AN960C10	NAS1149C0363 R	Purchased	No	130	Each	0.0000	7		11/13/24 10/10/10sf
 WASHER 									

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 62572

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C516

Purchased

No

130

Each

160.0000

1

1



WASHER



10/10/10 SP

Location

Loc Qty

Loc Code

ST347

160

102842

60

112532

100

1

D3454-1

Manufactured

No

130

Each

27.0000

1

1



Bushing



10/10/10 SP

Location

Loc Qty

Loc Code

ST058

27

58555

27

130

Each

27.0000

2

D3454-3

Manufactured

No



Bushing



10/10/10 SP

Location

Loc Qty

Loc Code

ST058

27

56420

27

130

Each

10.0000

2

D3454-5

Manufactured

No



Bushing



10/10/10 SP

Location

Loc Qty

Loc Code

ST058

10

58556

10

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 62572

Parent Item: D412-630-032


Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

 D3455-1
Spacer

Manufactured No

130 Each

34.0000

2

4
10/10/185

(PTO)

Location

Loc Qty

Loc Code

ST058


34

56525

3

59469

31

 D3455-3
Spacer

Manufactured No

130 Each

17.0000

2

4
2
10/10/185

Location

Loc Qty

Loc Code

ST058

17

56047

7

58559

10

 D3462-042
Bracket Assembly

Manufactured No

130 Each

7.0000

1

2
1
10/10/185

Location

Loc Qty

Loc Code

ST198A


7

35860

1

59471

6

 MS21043-3
Nut

Purchased No

130 Each

2,599.000

3

1
3
10/10/185

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2523

111383

46

112314

2477

3

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W/O: 62572		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		DB455-1 states Qty 2 of 4. MS24665-227 needs to be Qty 4. For packaging of 2 for Assembly. perm. Change	DA	10.20		10.10.19	10.10.19	

Part No: D412-630-032 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 62572

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

MS24665-227

Purchased

No

130

Each

41.0000

1

2



COTTER PIN

Location

Loc Qty

Loc Code

ST309

41

113845

41

MS24665-302

Purchased

No

Each

44.0000

1

1



Cotter Pin

Location

Loc Qty

Loc Code

ST309

44

113644

44

NAS1515H5

Purchased

No

130

Each

213.0000

1

1



Washer

Location

Loc Qty

Loc Code

FG

44

103286

17

103691

27

ST277

169

109430

169

D3455-1

Manufactured

No

Each

34.0000

2

2



Spacer

Location

Loc Qty

Loc Code

ST058

34

56525

3

59469

31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 62572

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3443-041 Manufactured No 110 Each 5.0000 1
Strut Weldment Assembly
Ep 10/10/14

Location	Loc Qty	Loc Code
ST198A	5	
56061	5	

D3463-042 Manufactured No 110 Each 0.0000 1
Step Weldment Assembly
B62561 1 Ep 10/10/14

D3443-9 Manufactured No 110 Each 8.0000 2
Pin
Ep 10/10/14

Location	Loc Qty	Loc Code
ST056	8	
58552	8	

AN4C14 Purchased No 110 Each 23.0000 1
BOLT
Ep 10/10/14

Location	Loc Qty	Loc Code
ST358	23	
113899	3	
114669	20	

MS24665-229 Purchased No 110 Each 169.0000 2
COTTER PIN
130 10/10/14

Location	Loc Qty	Loc Code
ST309	169	
111041	169	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 62572



Parent Item: D412-630-032



Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

MS24665-227



COTTER PIN

Purchased No

110

Each

41.0000

1



Ep 10/10/14

Location

Loc Qty

Loc Code

ST309

41

113845

41

AN4CH3



SS Bolt

Purchased No

110

Each

20.0000

2



Ep 10/10/14

Location

Loc Qty

Loc Code

ST355

20

114801

20

D3465-1



Washer

Manufactured No

110

Each

27.0000

1



Ep 10/10/14

Location

Loc Qty

Loc Code

ST059

27

46134

27

AN310-4



NUT

Purchased No

110

Each

31.0000

2



Ep 10/10/14

Location

Loc Qty

Loc Code

ST324

31

115107

31

D3443-043



Strut Weldment Assembly

Manufactured No

110

Each

4.0000

1



Ep 10/10/14

Location

Loc Qty

Loc Code

ST198A

4

56062

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 62572

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

[D3454-7]



Bushing

Manufactured No

110 Each

20.0000

2

2



Signature
10/10/14

Location

Loc Qty

Loc Code

ST058

20

55608

1

59256

19

2

[AN310-7]



NUT

Purchased No

110 Each

50.0000

1

1



Signature
10/10/14

Location

Loc Qty

Loc Code

ST324

50

114784

50

Y

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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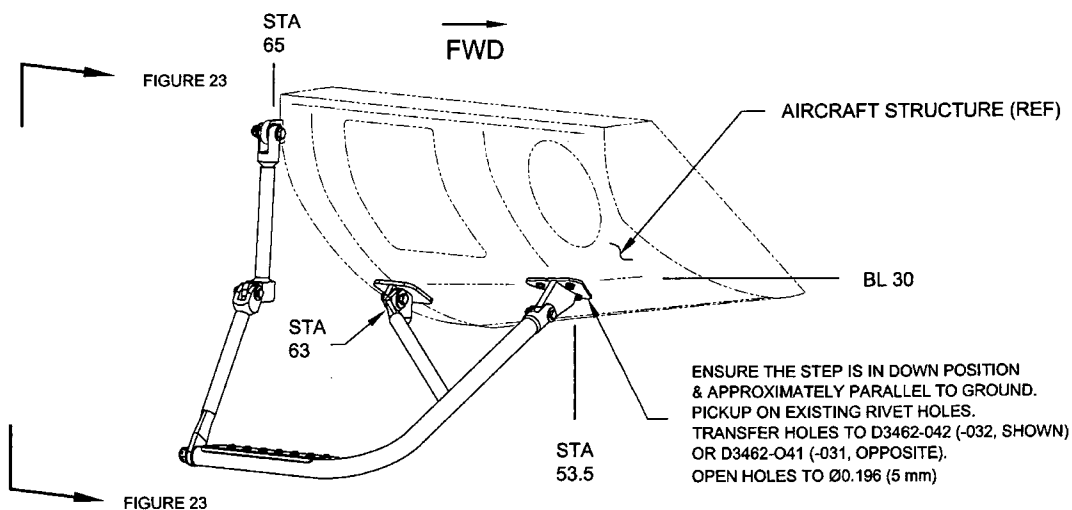
D412-630-031/-032 Pilot/Co-Pilot Folding-Step Installation

FIGURE 21 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown), D412-630-031 LH (Opposite)

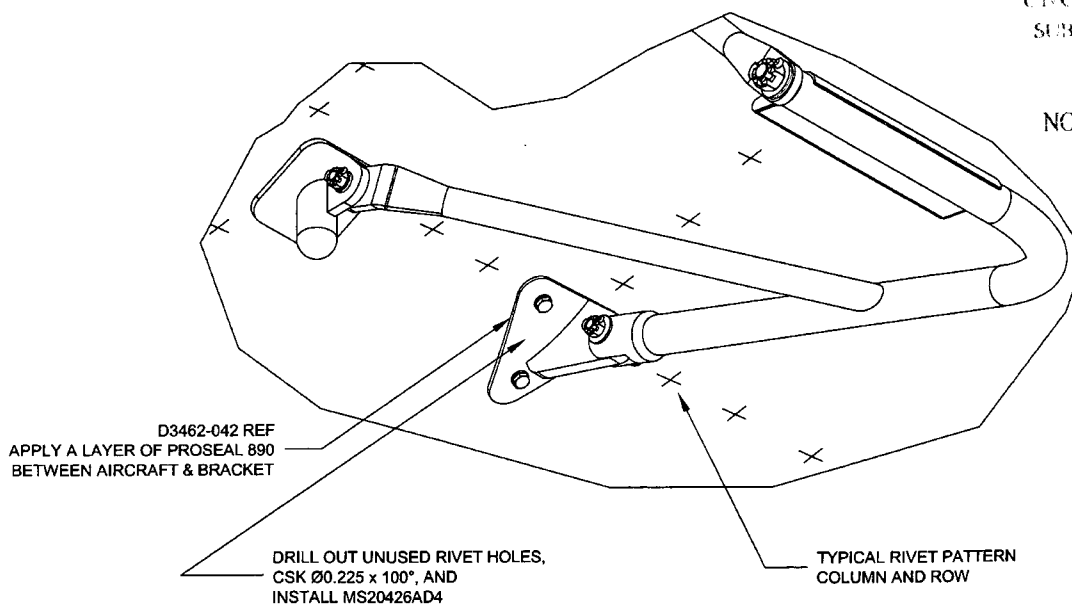


FIGURE 22 – Detail View D3462-042 Bracket Assembly (-032 Installation, Shown) D3462-041, (-031 Installation Opposite)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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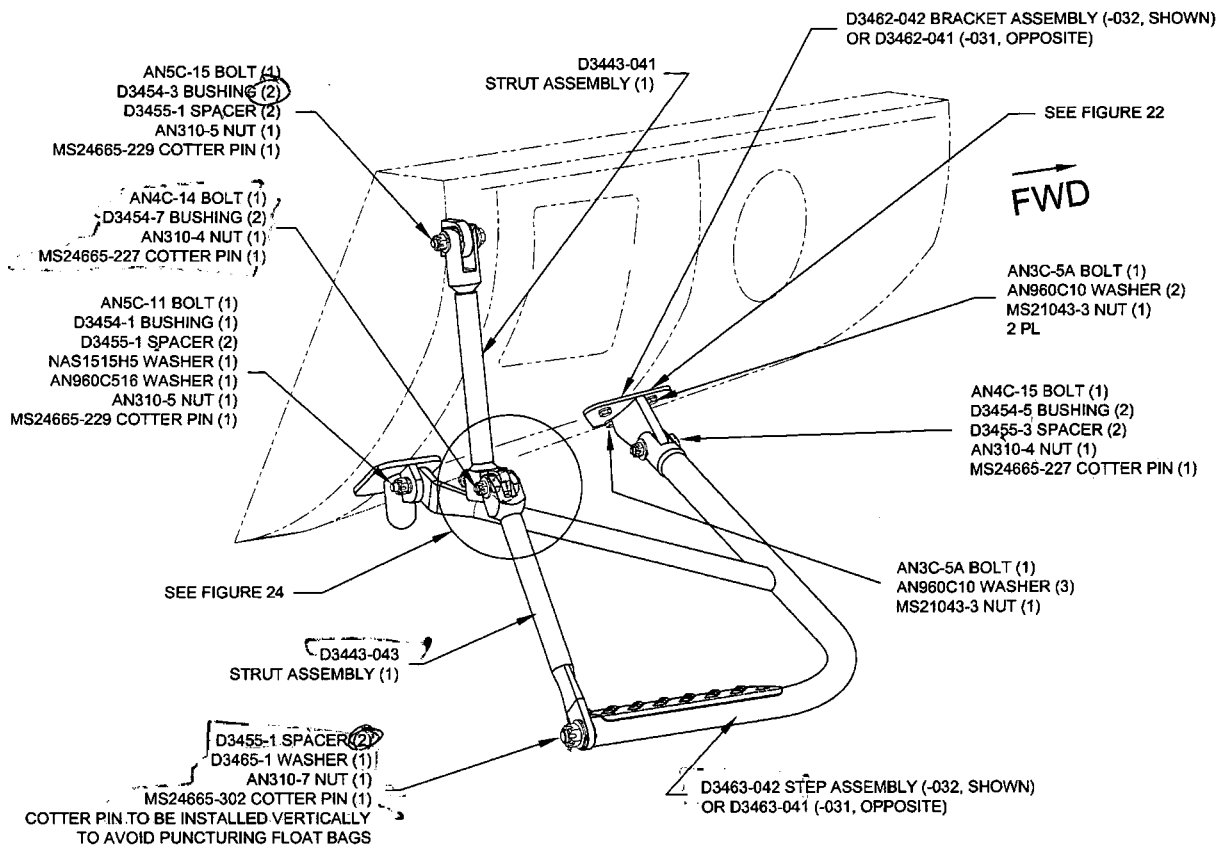


FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

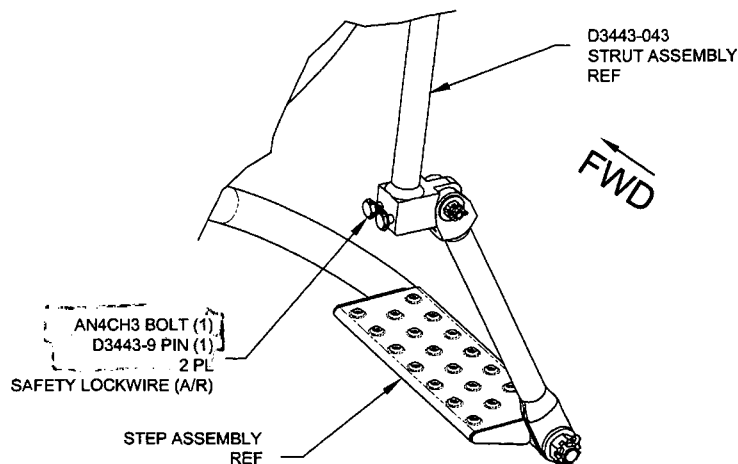


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

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Revision: M
Date: 08.12.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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